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Hawkesbury, ON
K6A 1K7
Canada

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D4635-143
Job Sheet 185370



0006752

Part No: D4635-143

Job Qty: 1 ea

Part Name: Aft Ceiling Replacement Panel Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/25/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4635 REV F SHEET 11 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg. Update 13/07/09 DL ver: DD IPP Rev D Dwg Update 13/12/09 DL Ipp Rev. E Dwg Update 14/01/09 DL IPP Rev. F Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/30/18	0.00	0.00	Start Up Small Fab		SMB
110	Small Fab	1 pcs		11/30/18	0.00	0.68	Small Fab		SMB
120	QC	1 pcs		11/30/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		11/30/18	0.00	0.00	Packaging3		SMB
140	QC21-SA	1 Ea		11/30/18	0.00	0.00	QC21		21

Part Op 110 - Assemble as per Dwg D4635-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Descriptions: Batch: M138715 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # M138958 Expiry Date April 19 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer (see note 9) Batch: M138961
120 - QC5- Inspect part completeness to step on W/O
130 - Identify as per dwg & Stock Location:
140 - QC21- Final Inspection - Work Order Release

9-85 DEC 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4635-3 <u>fs230</u>	Aft Ceiling Panel, LH	1 Ea (1 ea)	90-Start up Operation	S130770
D4669-1 <u>mfo03</u>	Bracket	1 Ea (1 ea)	90-Start up Operation	S132878
D4669-3 <u>mfo03</u>	Bracket	1 Ea (1 ea)	90-Start up Operation	S132878
D4695-3	Channel	1 Ea (1 ea)	90-Start up Operation	S132878
D4732-1 <u>mfo04</u>	Label	1 Ea (1 ea)	90-Start up Operation	S132878
D4732-13 <u>mfo04</u>	Label	1 Ea (1 ea)	90-Start up Operation	S132878
D4732-37 <u>mfo04</u>	Label	1 Ea (1 ea)	90-Start up Operation	S132878
D5022-3 <u>fs230</u>	Foam, Side Panel, Aft	1 Ea (1 ea)	90-Start up Operation	S132878

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4635-3	1	2	0
	D4669-1	1	4	0
	D4669-3	1	24	0
	D4695-3	1	1	0
	D4732-1	1	3	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

D4732-13
D4732-37
D5022-3

1
1
1

5
3
1

0
0
0

Part Specifications

Specifications could not be found.

Plex 10/25/18 1:00 PM Dart.lajeunesse.marie

DART
AEROSPACE

Container No. S134468

Part: D4635-143

Job No: 185370

Serial No/Batch: S134468

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/04/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					